Wachne per Long 02230 Rev. G

												DQA:	D	ate:	*
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORM	MANCE / UP	DATE					•
											Q	A Closed:	D	ate:	
Work Orde	a r ·					DISPOSITION				AGAINST DE	EP#	ARTMENT/	PROCESS		
Work Orde	٠					Rework	1		Skid-tube	Crosstube	7		Water Je	+	Engineering
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Cause		Date	Step	Qty	(or Non-conformance	Cł	nief Eng	Desc	ription	\perp	Date	Verificati	on	QC Inspector
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	\vdash	i				Broken/Damaged	L	Inspecti	on Incomplete		_ P	art Incorred	et		Weld
		Crushed/	Crimped			Burrs		Instruct	ioris Incomplete/	Unclear	P	art Lost/Mi	ssing	L	Wrong Stock Pulled
	Cracks Crushed/Crimped Cuffs			1	Contamination		Mainte	nance		Р	art Moved				

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

150

Chemical Conversion Coat per QSI005 4.1

0.00

150 HandFinish

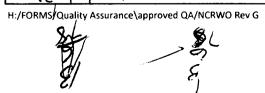
Memo

0.00

Hand Finishing

											DQA:	Date	: **
NCR: Y	'es	/ No				WORK ORDER NON-	COL	NFORM	MANCE / UP	DATE			
											QA Closed:	Date	•
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
Vork Orde	-					Rework	٦		Skid-tube	Crosstube]	Water Jet	Engineering
Part N	lo.					Scrap	1		Machining	Small Fab	Prod	d. Eng. Coor.	Quality
	-	•				Use-as-is	1		noforming	Finishing	4	e/Packaging	Other
NCR N	١o.					Work Order Update	1		Large Fab	Composite		Supplier	
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Root						iption of work order update		nitial		ction	Sign &		
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	_	Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re	<u> </u>	Over/Under	tolerance	Temperature/Cure
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	—	Crushed/0	Crimped			Burrs		i	ions Incomplete,	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	_	Cuffs	•			Contamination		Mainte	•		Part Moved	_	
	_	Heat Trea	t			Countersink		Mislabe	eled		Positioned V	V rong	
	\dashv	Inspection		Tube		Cut Too Short		Misread	i		Power Loss/		Other
		Ripples in	-			Drill Holes		Offset			· 	- <u>L</u>	
ر <u>ح</u>	-	Torque W		xtrusio	n	Drawing		Out of 0	Ca'ibration				
		Turning S	equence			Finish		Out of S	Sequence				
	Turning Sequence Wave/Twist in Tube				Folio		Outside	Dimensions					





Work Order ID 9448	5
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Quality Control

94485

Page 3

December-19-12 11:26:39 AM Item ID: D2230-3 Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Lug **Start Oty: 120.00** *120* **Start Date:** 1/29/13 **Cust Item ID:** Req'd Oty: 120.00 Required Date: 1/29/13 **Customer:** Reference: Run Start Date: **Approvals:** Process Plan: **Tooling:** Date: Stop Date: _____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description Code Qty Qty Number Stamp **Run Hours** QC3-Inspect Part Finish 160 0.00 *160* 0.00 Memo Quality Control 170 0.00 200 \$ BL 18-1-4. *170* 0.00 Powdercoat Powder Coating QC3- Inspect Part Finish 0.00 180 200 × 4 14 13/01/17 0.00 Memo

										DQA:	Dat	:e: _	ب
NCR: Y	es / No				WORK ORDER NON-C	COI	NFORM	ANCE / UPI	DATE				
					·			,		QA Closed:	Dat	te:	
Work Orde	r.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part N NCR N	lo				Rework Scrap Use-as-is Work Order Update		t Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-∤	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root				Descri	ption of work order update		Initial	Act	tion	Sign &			
Cause	Date	Step	Qty	(or Non-conformance	Cr	nief Eng	Desci	ription	Date	Verification	1	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
						AUI	LT CATE	GURY					
Landin	Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped			o/s	General Bend BOM/Route Broken/Damaged Burrs		⊣ `	ire ion Incomplete cioris Incomplete/I	Unclear	Ovalized Over/Under Part Incorre Part Lost/M	ct		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	Crushed/Crimped Cuffs		Contamination		Mainte	•	Officieal	Part Moved	_	Ш	TOTAL STOCK FULLED		

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

	Work Order ID 94485 December-19-12 11:26:39 AM		·	*944	185*					Page 4		
Revision ID: Item Name:	D2230-3 Lug			Accept	*N900	040	100)* :	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	1/29/13 1/29/13	Start Qty: 120.00 Req'd Qty: 120.00	*120 *120	=	Cust Item I Customer:	D:	_		_	64 4		
Approvals:	Process P	Plan:	Date:	Tooling: SPC (Y/N):		ate:ate:]	Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II)	Operation Description Identify as per dwg & Sto	ck Location:	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt	-	Reject Number	Insp. Stamp
100 Packaging Packaging		Memo	57469	0.00					- /-	43	6//	7 (22
200 *200* QC		QC21- Final Inspection -	Work Order Release	0.00						13/	01/2	22 \$

Quality Control

												DQA:	Da	ate:	۵
NCR:	Yes	/ No				WORK ORDER NON-O	COL	NFORM	MANCE / UP	DATE					
<u>,</u>								,				QA Closed:	Da	ate:	
Work Ord	or.					DISPOSITION				AGAINST D	Œ	PARTMENT	/PROCESS		
WORK OIG	۲۱.					Rework	1	Skid-tube Crosstube			\neg		Water Jet		Engineering
Part I	Vo.					Scrap Machining			}	Small Fab	\dashv	Pro	d. Eng. Coor.	\vdash	Quality
, , ,						Use-as-is Thermoforming			Finishing	\dashv		e/Packaging		Other	
NCR	No.					Work Order Update	1	•	Large Fab	Composite	\dashv	•	Supplier	-	
Root					1	ption of work order update	ł	Initial	Ac ⁻	tion		Sign &			
Cause		Date	Step	Qty	,	or Non-conformance	Ch	nief Eng	Desc	ription	_	Date	Verification	'n	QC Inspector
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		Cracks				Broken/Damaged		Inspecti	ion Incomplete			Part Incorre	ct		Weld
	Crushed/Crimped		Burrs		Instruct	ions Incomplete/	Unclear		Part Lost/Mi	issing		Wrong Stock Pulled			

Maintenance

Out of Calibration
Out of Sequence

Outside D mensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio Part Moved

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Picklist Print

December-19-12 11:26:39 AM

Work Order ID:

94485

Parent Item:

D2230-3

Parent Item Name:

Lug

Start Date: 1/29/13

Required Date: 1/29/13

Start Qty: 120.00

Required Qty: 120.00

Page 1

Comments:

IPP D00.05.18Added inspection level 8, and removed P/O for powder

coatEC

IPP REV :E NEW FOLIO # 10-05-25 JLM VERIFIED

BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
D2230-3P		Purchased	No				Each	0.0000		_120	300	11,2/1/2 (
LUG												142/01/1
D2423		Manufactured	No			100	f	425.4340	0.0683	8.627364	4 ~ 0	
Lug Extrusion											(Z)	13/01/03_
				Location		Loc Oty	Lo	oc Code				
				MAT006		425.434						
				437	22	161.5					,	
				879	53	263.934				_13.6	7	•

F >

											DQA:	Da	te:	
NCR: \	/es	/ No				WORK ORDER NON-C	100	NFORN	NANCE / UPDATE					
				····		<u>,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,</u>					QA Closed:	Da	te:	
Work Orde	er:				•	DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part N	- ا ۱۰۰					Rework Scrap Use-as-is Work Order Update			Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Description		Date	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,						F	AUL	T CATE	GORY		<u> </u>	<u> </u>		
Landi	ng G	ear				General								
		Bending Centre No Cracks	ot Concer	ntric to	o/s	Bend BOM/Route Broken/Damaged		Grain Hardwa	re on Incomplete		Ovalized Over/Under Part Incorre			Pressure/Forced Temperature/Cure Weld
	\vdash	Crushed/	Crimned		<u> </u>	Burrs		₹	ions Incomplete/Unclear		Part Lost/M			Wrong Stock Pulled
		Cuffs	crimped		-	Contamination	_	Mainte			Part Moved	=		1ong Stock i diled
	\vdash	Heat Trea	nt			Countersink	-	Mislabe		\vdash	Positioned \			
	\vdash	Inspection		Tube		Cut Too Short		Misread		-	Power Loss/	_	Γ-	Other
	_	Ripples in	•			Drill Holes		Offset		<u> </u>	⊿		_	

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	94485
Description: Mounting Lug	Part Number:	D2230-3
Inspection Dwg: D2230 Rev: G		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.450	+/-0.010	,				
0.413	+/-0.010					
0.306	+/-0.010					
3.700	+/-0.010					
0.750	+/-0.010					
Ø0.257	+0.005/-0.000					
0.375	+/-0.010					
R1.200	+/-0.010					
0.100 x 45°	+/-0.010					
				,		
, , , , , , , , , , , , , , , , , , ,					***************************************	
		•				
		Mannaninini				
				·		

Measured by:	Audited by:	Preliminary Approval:	N/A
Date:	Date:	Date:	N/A

Rev	Date	Change	Revised b	у	Approved	1
Α	03.11.11	New Issue	KJ/RF ,	_	11	
В	10.08.03	Dimensions updated per Dwg Rev G	KJ 🗘	4-	<u>M</u>	
				T		

D2230-1

D2230-1 MOUNTING LUG

RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER MUS 12-12-19 D2230-3

D2230-3 MOUNTING LUG



SHOP COPY

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.				09.01.16	
F	REDESIGN; R1.200 WAS 1.100			CP	99.12.13	
E	RE-DESIGN			BW	95.01.04	
Ð	RE-DESIGN			BW	95.01.04	
С	RE-DESIGN			BW	94.03.30	
REV.	DESCRIPTION			BY	DATE	
DESIGN BW		BW	DART AEROSPACE LTD			
DRAWN AJS		AJS	HAWKESBURY, ONTARIO, CANADA			
CHECKED		51	DRAWING NO.		REV. G	
MFG. APPR.		Cod.	D2230		SHEET 1 OF 3	
APPROVED N		M	TITLE	SCALE		
DE APPR.		-1	MOUNTING LUG			
DATE 09.01.16			COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS REPORTE AND COMPRISHMENT, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PROPED OR COMPANY AND TO TO TO THE ORDER PORSON WITHOUT			

G

D

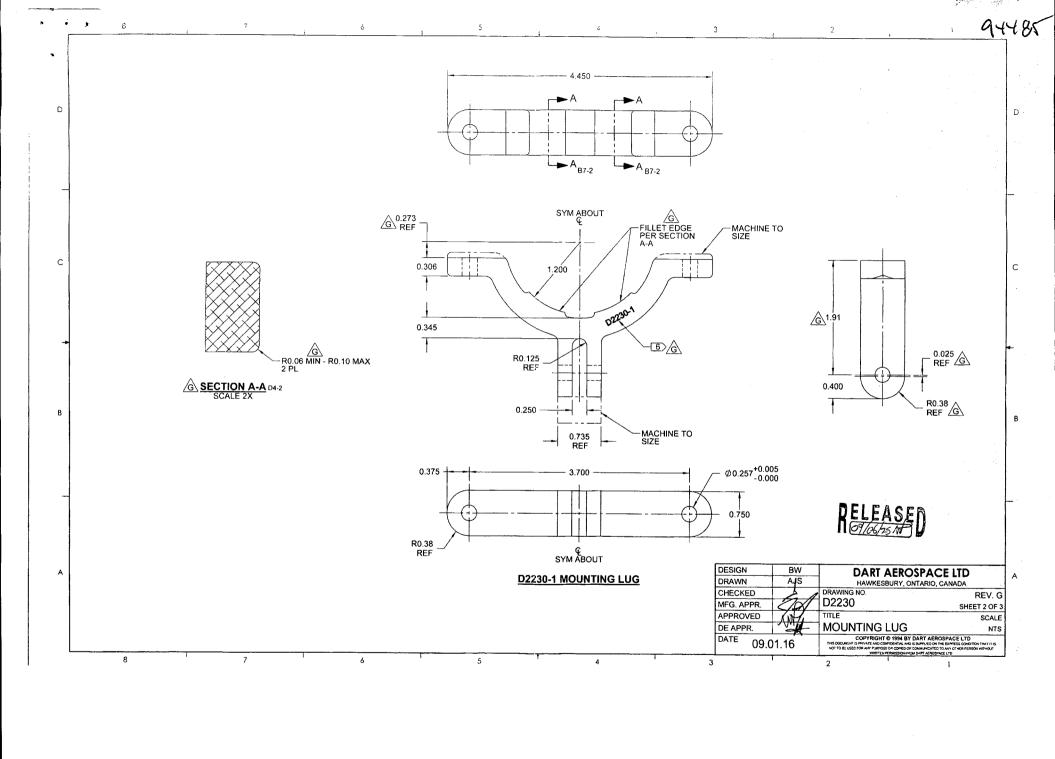
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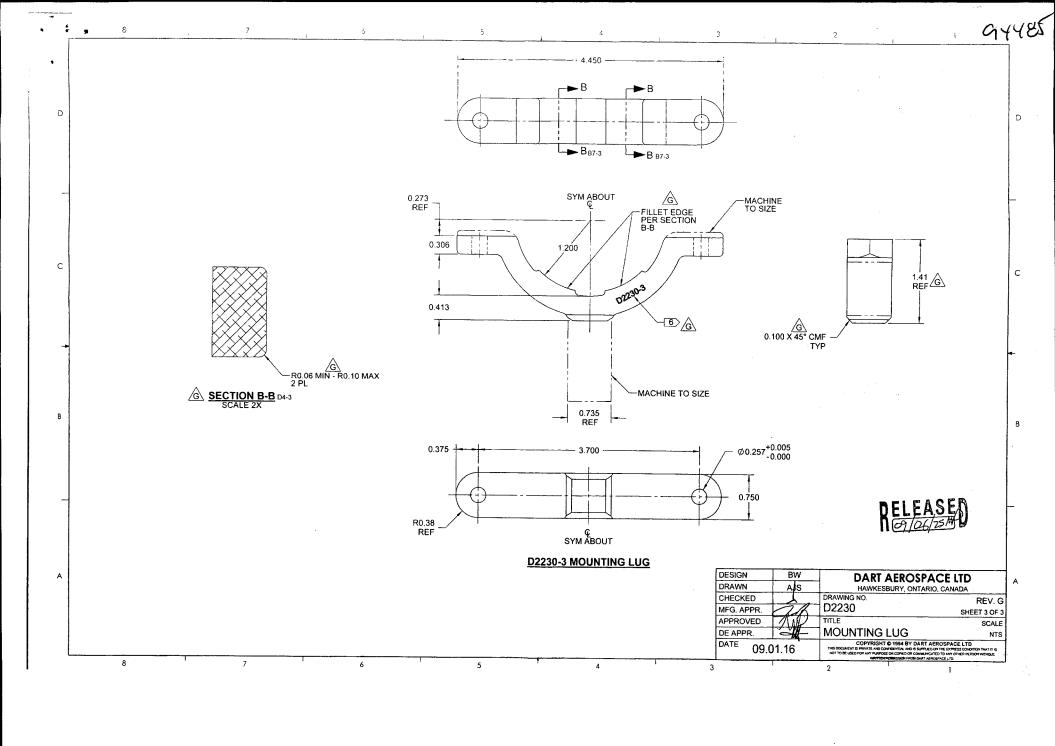
7

NOTES:
1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ±0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015+0.005

OF 0.015±0.005.
7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

8







Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO18704

Purchase Order Date 1/04/13 PO Print Date 1/04/13

Page Number 1 of 1

Order From:

VC-MET003

METEC METAL TECHNOLOGY INC. 20 TERRY FOX DRIVE PO BOX 781 VANKLEEK HILL, ON KOB 1R0

CA

Contact Name

Vendor Phone Vendor Fax

613 678 3957

Vendor Account Nbr

613 678 3956

Buyer Requisition Nbr

Tax Resale Nbr **Terms**

Currency **FOB**

Chantal Lavoie

10127-2607 Net 10

CAD

Destination-Collect

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN HAWKESBURY, ON K6A 1K7 **CANADA**

Li	ne Nbr Reference Revision ID Vendor Part Num	Description/ Mfg ID ber	Req Date/ Taxable Un	Req Qty/ it of Measure	Ship Method	Unit Price	Extended Price
1	D2230-3P	LUG	1/07/13 Yes	200.00 Each	Yours ppd	\$13.6000	\$2,720.00
		Special Inst:	AS PER DWG D22 B94485	30 REV. G			
2	D2230-3P	LUG	1/18/13 Yes	180.00 Each	Yours ppd	\$13.6000	\$2,448.00
		Special Inst:	AS PER DWG D22 B94957	30 REV. G			
3	D2230-1P	LUG	1/07/13 Yes	200.00 Each	Yours ppd	\$18.9500	\$3,790.00

CENTIFICATE OF CONFORMITY HEQ'D UPON DELIVERY

Special Inst:

AS PER DWG D2230 REV. G

B95217

PO Total:

\$8,958.00

No substitution or deviation without consent.

Certificate of Conformity or Material Certification required -YES NO

Change Nbr:

Change Date: 1/04/13

20 Terry Fox Drive Vankleek Hill, Ontario K0B 1R0, Canada Tel: (613) 678-3957 Fax: (613) 678-3956

your truck

Shipped By:

Delivery Slip No.:

18938

Date:

Jan 07, 2013

Page:

1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkespury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 18704	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date:

	Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-3	Mounting Lug	Each		200	
D2230-1	Mounting Lug	Each		200	
·					
		A. David			
Should there b	goods must be inspected upon receipt to confirm compliance. e discrepancies please notify METEC within 30 days of delivery. otherwise deemed accepted.				
	by Parin Man	Thanl	k you for yo	our order!	<u> </u>

20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

SHIPPED TO:

Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ont. K6A 1K7

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

200 200 D2230-3 D2230-1

Lug Lug 18704 18704

MATERIAL: supplied by DART B87953

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

Vankleek Hill, January 7, 2013

200